



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3235-1

Job Sheet 178500



Split to 180477 *cmf*

Part No: D3235-1

Job Qty: 200 ea

156.

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D3235 REV.A IPP A 04.04.19 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	200 pcs		7/6/18	0.00	0.00	Purchasing		RA 7/6/2018
120	Packaging	200 pcs		7/6/18	0.00	0.00	Packaging2		RA DAS 7/6/2018
130	QC	200 pcs		7/6/18	0.00	0.00	QC6		38 9-89
140	HandFinish	200 pcs		7/6/18	0.00	1.60	HandFinish1		
150	QC	200 pcs		7/6/18	0.00	0.00	QC3		
160	Powdercoat	200 pcs		7/6/18	0.00	1.89	Powdercoat1		
170	QC	200 pcs		7/6/18	0.00	0.00	QC3		
180	Packaging	200 pcs		7/6/18	0.00	0.00	Packaging3-1		JUL 17 2018
190	QC21-SA	200 Ea		7/6/18	0.00	0.00	QC21		

Part Op 110 - Issue P/O to Metec: 40084 Machine as per dwg C of C is required
Descriptions: 120 - Ensure C of C is attach

160 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

JUN 01 2018

DAS

13

X200 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	13.6600 ft (.0683 ea)	110-Purchasing	5067430
D3235-1P	Lug	200 pcs (1 ea)	110-Purchasing	5089598

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	14	696	0
	D3235-1P	200	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Log	4.450inches ± 0.010	4.460 4.440		
2	Mounting Log	0.306inches ± 0.010	0.316 0.296		
3	Mounting Log	1.850inches ± 0.030	1.880 1.820		
4	Mounting Log	1.200inches ± 0.010	1.210 1.190		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>					Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :			MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition			Completed By																	
					Lead hand / Supervisor Approval Verification																	
					QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																				
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OTHER :																						

5	Mounting Log	0.125inches ± 0.010	0.135 0.115
6	Mounting Log	0.400inches ± 0.010	0.410 0.390
7	Mounting Log	0.735inches ± 0.030	0.765 0.705
8	Mounting Log	0.505inches + 0.005 - 0.000	0.510 0.505
9	Mounting Log	0.380inches ± 0.030	0.410 0.350
10	Mounting Log	3.700inches ± 0.005	3.705 3.695
11	Mounting Log	0.375inches ± 0.010	0.385 0.365
12	Mounting Log	0.750inches ± 0.010	0.760 0.740
13	Mounting Log	0.257inches + 0.005 - 0.000	0.262 0.257
14	Mounting Log	0.380inches ± 0.030	0.410 0.350

Plex 6/1/18 7:33 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

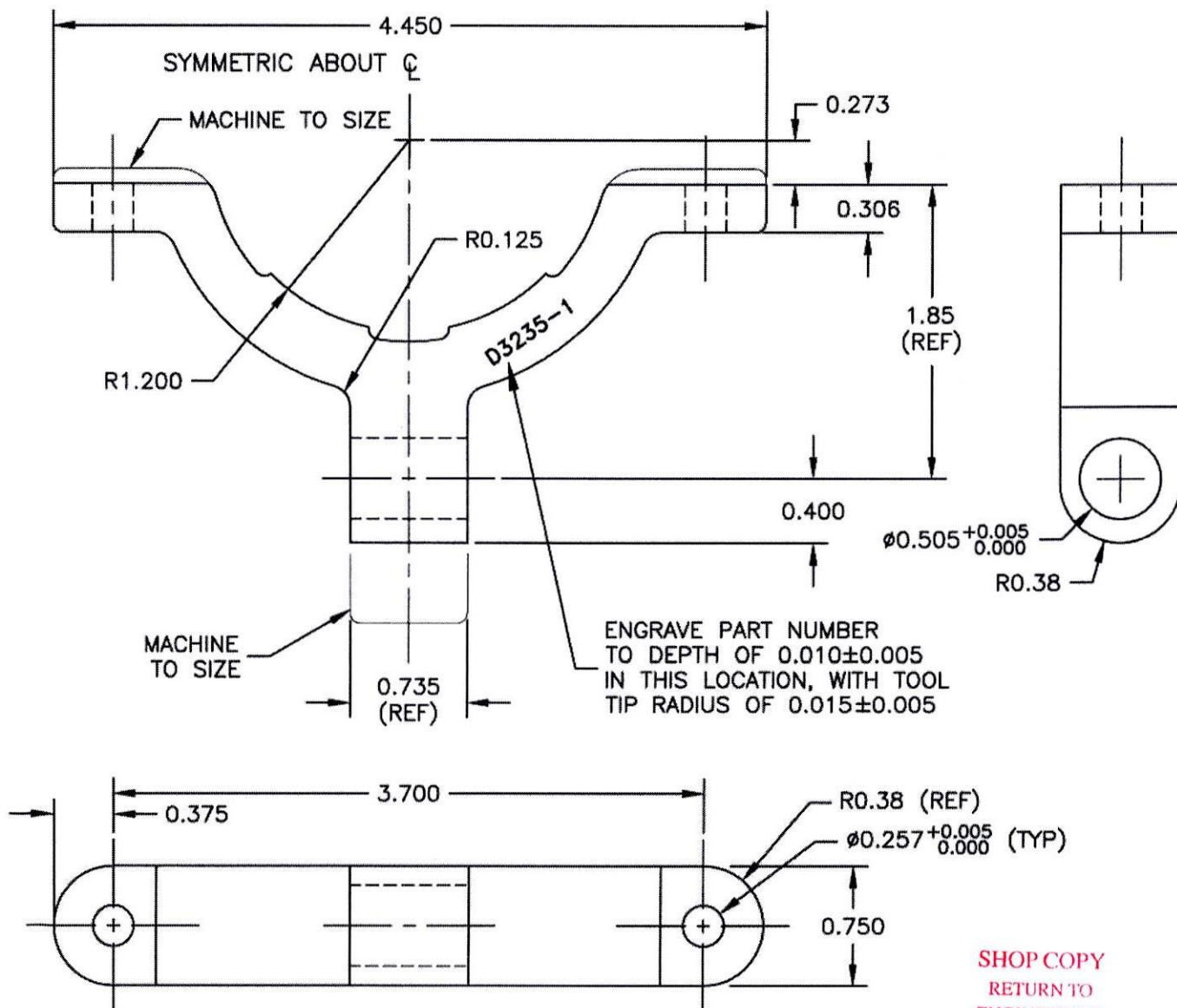
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3235	SHEET 1 OF 1
DATE	04.03.02	TITLE	MOUNTING LUG	SCALE	1:1
A	04.03.02	NEW ISSUE			

RELEASED
040405



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 178500 MJS
18-06-01

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DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040086

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040086

PO Date: 6/1/18

Due Date: 7/9/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavole, Chantal
Phone: clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
JUN 01 2018

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QS1005	Firmed	7/9/18	200 pcs	0 pcs	200 pcs	\$13.80/pcs	\$2,760.00
Line Item Note w/o 178494											
2	D3235-1P			Lug As Per Dwg D3235 Rev. A Alodine and Paint as per QS 1005	Firmed	7/9/18	200 pcs	0 pcs	200 pcs	\$15.00/pcs	\$3,000.00
Line Item Note w/o 178500											

Grand Total: \$5,760.00

Order Notes

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 6/1/18 1:22 PM dart.lavoie.chantal



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
156	D3235-1	Lug	160522	22188	40086

DART
38
9-89

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, June 28, 2018